

**Work Order ID 81000**

Tuesday, March 06, 2012 11:46:07 AM

**\*81000\***

Page 1

Item ID: D3940-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Protector (407)

Start Date: 3/6/2012 Start Qty: 3.00

**\*3\***

Cust Item ID:

Required Date: 3/12/2012 Req'd Qty: 3.00

**\*3\***

Customer:

Reference:

Approvals: Process Plan: *ME*Date: *12-03-06* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

Draw Nbr

Revision Nbr

100

0.00

**\*100\***

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

*x3**DL*  
*12/03/07*

105

0.00

**\*105\***

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: *240°F*Time IN: *7:00 pm 12/03/06*Time OUT: *6:00 am 12/03/07**x3**DL*  
*12/03/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81000**

Tuesday, March 06, 2012 11:46:07 AM

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Page 2

Item ID: D3940-1

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Protector (407)

Start Date: 3/6/2012 Start Qty: 3.00 **\*3\***

Cust Item ID:

Required Date: 3/12/2012 Req'd Qty: 3.00 **\*3\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

110

0.00

**\*110\***

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA042 using tool DT9502  
Dwg Rev: A  
Folio Rev: B

x3

OK  
12/03/07

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

x3

OK  
12/09/07

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

x3

B  
12/03/08

W/O:		WORK ORDER CHANGES					
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**Work Order ID 81000**

Tuesday, March 06, 2012 11:46:07 AM

**\*81000\***

Page 3

Item ID: D3940-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Protector (407)

Start Date: 3/6/2012 Start Qty: 3.00 **\*3\***

Cust Item ID:

Required Date: 3/12/2012 Req'd Qty: 3.00 **\*3\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140

**\*140\***

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x3

Dh.  
12/03/08

150

**\*150\***

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Complete FAI document

x

Dh.  
4/03/08

160

**\*160\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/20/08

(x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81000**

Tuesday, March 06, 2012 11:46:07 AM

**\*81000\***

Page 4

Item ID: D3940-1

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Floor Protector (407)

Start Date: 3/6/2012 Start Qty: 3.00 **\*3\***

Cust Item ID:

Required Date: 3/12/2012 Req'd Qty: 3.00 **\*3\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

170

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

12/3/08 (30)

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

MLJ 12/03/08

MLJ 12/03/08  
(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, March 06, 2012 11:46:06 AM

Page 1

Work Order ID: 81000

Parent Item: D3940-1

Parent Item Name: Floor Protector (407)

Start Date: 3/6/2012

Required Date: 3/12/2012

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev. A New Issue 09/02/06 DL  
Material 10/04/21 DL

IPP Rev B Add Step 105 Dry

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08 Lexan Sheet		Purchased	No			100	sf	1,503.3969	9.03	27.09			

Location

therm

Loc Qty

1503.396941

1503.39694

Loc Code

27.09 sq ft.

DL  
12/03/08

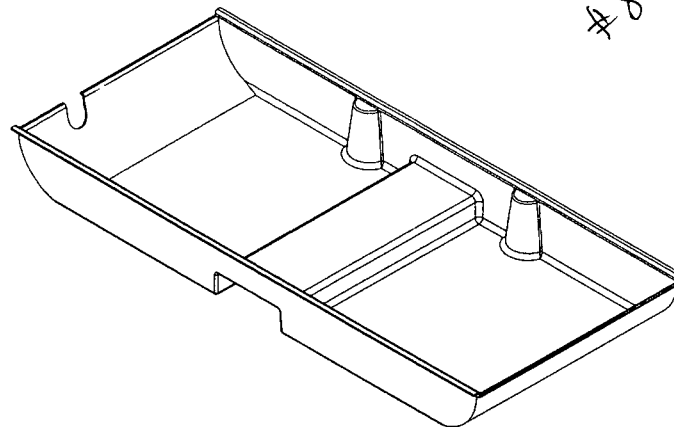
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D3940-1 FLOOR PROTECTOR (407)**

**RELEASED**  
09/04/01

**NOTES:**

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3940-1" USING VIBRATING STYLUS
- 7) WEIGHT: 4.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9502 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A	NEW ISSUE	PH	09.04.01
REV.	DESCRIPTION		BY DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3940	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FLOOR PROTECTOR (407)	NTS
DATE	09.04.01	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

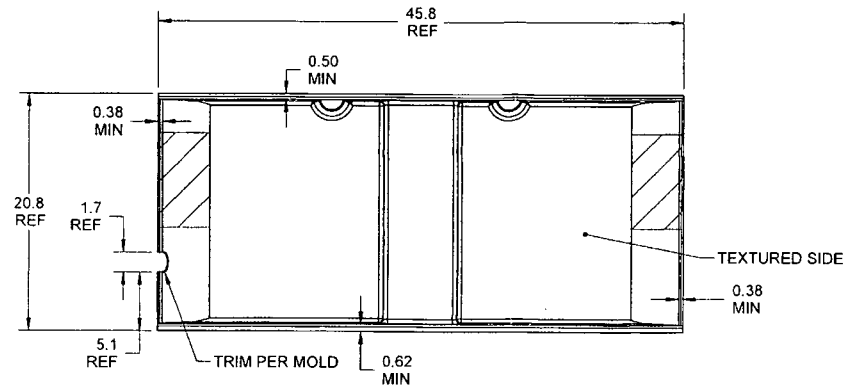
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

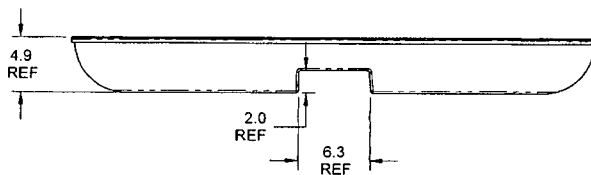
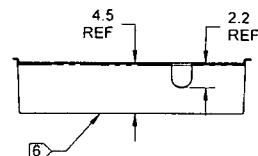
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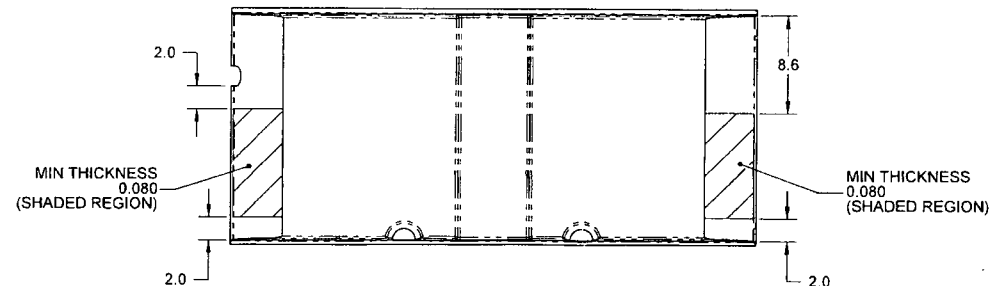
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B

B



A

A

**D3940-1 FLOOR PROTECTOR (407)**

#81006

**RELEASED**

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED			DRAWING NO. <b>D3940</b>	REV. A
MFG. APPR.				SHEET 2 OF 2
APPROVED			TITLE	SCALE
DE APPR.			<b>FLOOR PROTECTOR (407)</b>	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	81000
<b>Description:</b> Floor Protector		<b>Part Number:</b>	D3940-1
<b>Inspection Dwg:</b> D3940	<b>Rev:</b> A	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by:

Date:

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
45.8	REF	45.75"	✓			
20.8	REF	20.8"	✓			
0.50	Min	0.539"	✓			
0.62	Min	0.64"	✓			
0.38	Min	0.395"	✓			
0.080	Min	0.085"	✓			
0.050	Min	0.060"	✓			

Measured by:

Date:

Audited by:

Date:

Prototype Approval:

N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	09.09.17	New Issue	KJ	AA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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